

Date: Monday, 09/03/2009 3:30:25 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : BASKET BASE ASSEMBLY (350)
 Job Number : 46368A
 Estimate Number : 10189
 P.O. Number :
 This Issue : 09/03/2009 S.O. No. :
 Prsht Rev. : NC Part Number : D2221
 Drawing Number : D2221 REV H
 Project Number : N/A
 First Issue : / / Type : LARGE FAB ASSY Drawing Revision : H
 Material :
 Previous Run : 46062A Due Date : 17/03/2009 Qty: 1 Um: Each

Written By :
 Checked & Approved By : JUD 09.03.09

Comment : Est Rev:J 05.09.02 Added D3442-1 KJ/JLM
 Est Rev:K 08-08-29 revG as per dwg DD verified by:EC
 Est Rev:L 08-09-24 plug holes prior to powder coat DD
 verified by:EC
 Est Rev:M 08-12-02 revH as per dwg DD verified by:

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

D22211

Rib



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Rib

batch: B 46388 → Lx

JS 09/03/23

2.0

D22215

Rib



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Rib

batch: B 46082 → 2x

JS 09/03/23

3.0

D22217

Rib



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Rib

batch: B 46083 → 1x

JS 09/03/23

4.0

D22323

Basket Hinge



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Basket Hinge

batch: B 46389 → 2x

JS 09/03/23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 09/03/2009 3:30:25 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET BASE ASSEMBLY (350)

Job Number: 46368A

Part Number: D2221

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D22351

Basket Rib



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Basket Rib

batch: B46474 → 2x

dy 09/03/23

6.0

D2581

Mounting Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Mounting Bracket

batch: B45684 → 2x

dy 09/03/23

7.0

D34421

Shim



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Shim

batch: B45226 → 2x

dy 09/03/23

8.0

D3825041

Rib Assembly (Basket End)



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Rib Assembly (Basket End)

batch: B46087 → 2x

dy 09/03/23

9.0

D3826041

Rib / Gusset Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Rib / Gusset Assembly

batch: B46367 → 2x

dy 09/03/23

10.0

D3827041

Rib Assembly (Inboard)



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Rib Assembly (Inboard)

batch: B46090 → 1x

dy 09/03/23

11.0

D38331

Mesh (Base End Face)



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Mesh (Base End Face)

batch: B46091 → 2x

dy 09/03/23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET BASE ASSEMBLY (350)

Job Number: 46368A

Part Number: D2221

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

D38321

Mesh (Base)



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Mesh (Base)

batch: MB 45944

SL 09/03/23

13.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1- assemble all ribs and both D2581 in DT9444 jig, weld as per dwg D2221

2- remove basket from jig and weld D3442-1 shims and D2232-3 hinges as per dwg D2221

3- tack weld mesh on basket as per dwg D2221

A/R ER316 S.S. Rod Batch: M108775

SL 09/03/24 (1x)

14.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

SL 09-03-25

15.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

SL 09/03/25

16.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

m110939-

1- Plug holes prior to powder coating

2-Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

1ST COAT:

START TIME: 1:00

OVEN TEMPERATURE: 400°

FINISH TIME: 1:30

***** 2nd coat if necessary*****

2ND COAT:

START TIME: 1:45

OVEN TEMPERATURE: 400°

FINISH TIME: 2:15.

FL 09/03/25 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 09/03/2009 3:30:26 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET BASE ASSEMBLY (350)

Job Number: 46368A

Part Number: D2221

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Sorter/38 @

18.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/04/01

Job Completion



mf
09-03-31

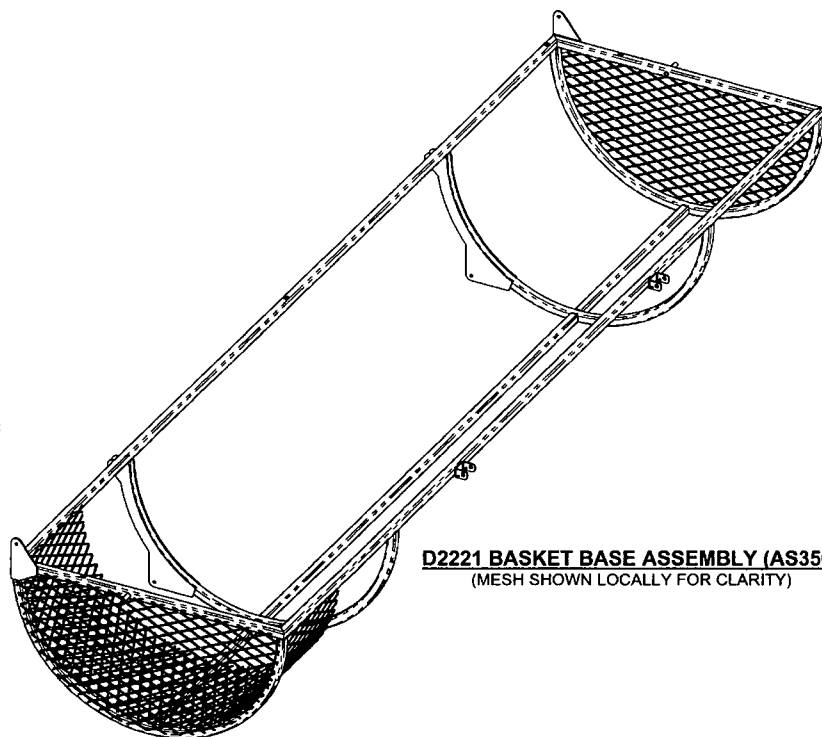
Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D2221 BASKET BASE ASSEMBLY (AS350)
(MESH SHOWN LOCALLY FOR CLARITY)

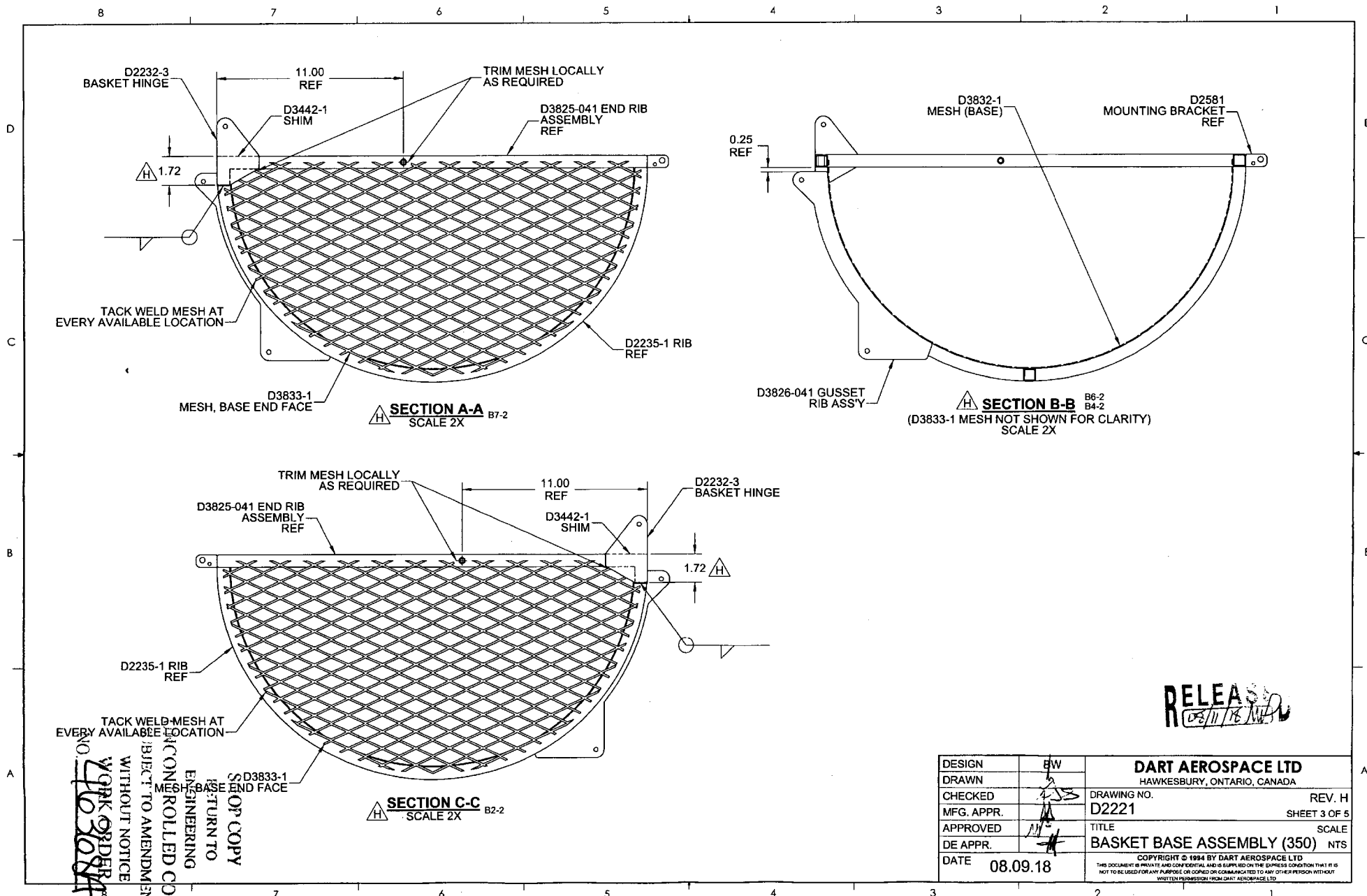
ITEM	QTY	P/N	DESCRIPTION
1	X	D2221	BASKET BASE ASSEMBLY (AS350)
2	1	D2221-1	RIB
3	2	D2221-5	RIB
4	1	D2221-7	RIB
5	2	D2232-3	BASKET HINGE
6	2	D2235-1	RIB
7	2	D2581	MOUNTING BRACKET
8	2	D3442-1	SHIM
9	2	D3825-041	RIB ASSY (BASKET END)
10	2	D3826-041	RIB/GUSSET ASSY
11	1	D3827-041	RIB ASSY (INBOARD)
12	2	D3833-1	MESH, BASE END FACE
13	1	D3832-1	MESH (BASE)

REVISIONS
06/11/18

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- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: POWDER COAT GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 42.00 lbs APPROX
 - 8) MASK ALL HOLES PRIOR TO POWDER COATING

H	REVISED PARTS LIST AND ADDED "ITEM" COLUMN TO PARTS LIST (ZN D3-1); REVISED SECTIONS A-A, B-B AND C-C (ZN C8-3, C2-3 AND A6-3); REVISED DETAIL D (ZN B7-4); ADDED DETAIL E (ZN A6-4); ADDED SECTION F-F (ZN B2-4); ADDED DWG DETAILS FOR D2221-1/5/7 (SHEET 5); TOL REVISED TO 2 DEC PLACES (ZN D8-3 AND ZN B4-3); D3825-041 REPLACES D2221-3/D2327-3; D3826-041 REPLACES D2235-1/D2325; D3827-041 REPLACES D2221-1 ON INBOARD SIDE; ADDED D3832-1 AND D3833-1. REASON: SATISFY "LEAN MANUFACTURING" PROGRAM.	MB	08.09.18
G	MATERIAL FOR -1, -3, -5 & -7 WAS 0.060 WALL; TOLERANCE FOR 98.00 DIM WAS +/-0.01 AND 98.00 DIM WAS REF (ZN B5-2); 19.62 DIM WAS "HARD" DIMENSION IS NOW "REF" (ZN B4-2); NOTE 5 TRANSFERRED FROM SHT 1 TO SHT 2; SHT 2 MESH MATERIAL UPDATED; DRAWING TRANSFERRED TO "B" FORMAT	AJS	08.06.16
F	ADD SHIM UNDER HINGE; ADD HOLES FOR SPLIT LID BASKET	PH	05.06.07
E	CHANGE HINGE	CP	01.04.19
D	CHANGE LATCH	BW	96.06.21
C	SEPARATE BASKET AND LID	KH	95.11.21
REV	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED	JSS	DRAWING NO.	REV. H
MFG. APPR.		D2221	SHEET 1 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (350)	NTS
DATE	08.09.18	<small>COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	



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08/11/18

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DRAWN	JS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JS	DRAWING NO.	REV. H
MFG. APPR.	JS	D2221	SHEET 3 OF 5
APPROVED	JS	TITLE	SCALE
DE APPR.	JS	BASKET BASE ASSEMBLY (350) NTS	
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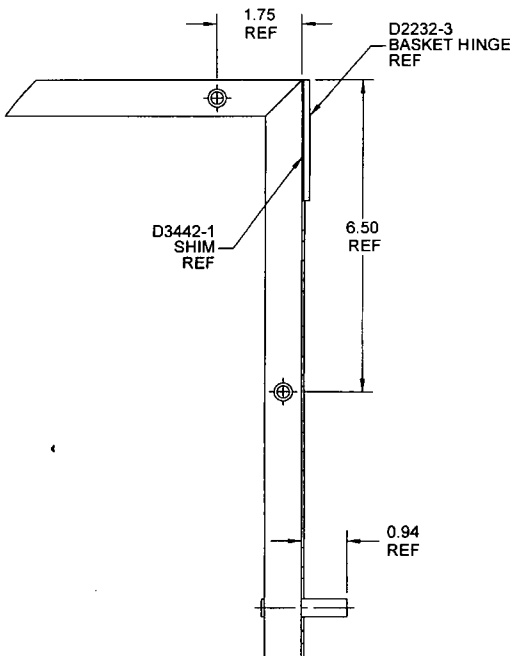
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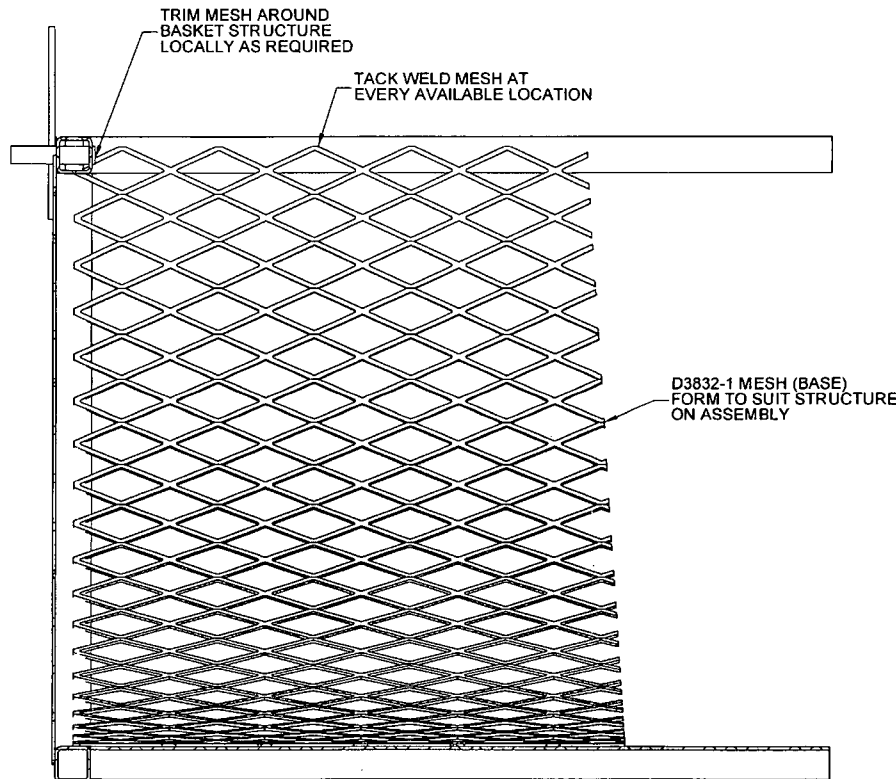
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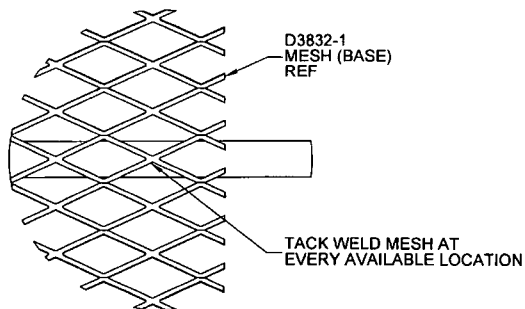
A



DETAIL D
SCALE 4X D2-2



SECTION F-F
SCALE 4X D7-2



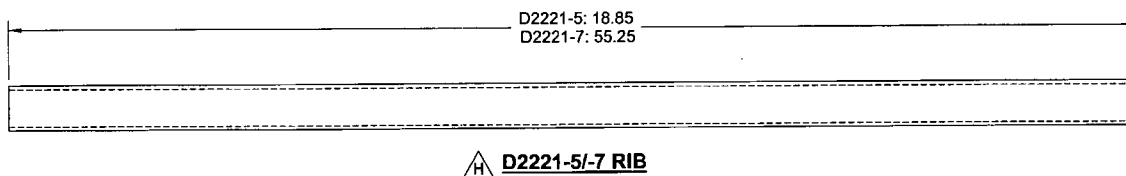
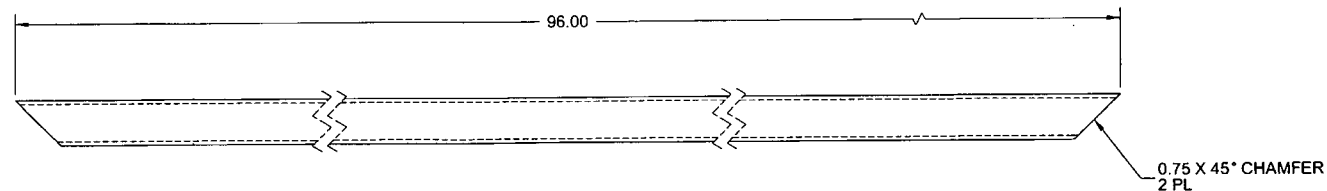
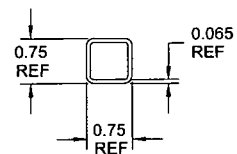
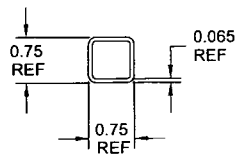
DETAIL E
SCALE 4X C6-2

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02/11/18

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MFG. APPR.		D2221	SHEET 4 OF 5
APPROVED	12/18	TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (350) NTS	
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WORK ORDER
NO. 1403087

8 7 6 5 4 3 2 1



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- NOTES:
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL REF. DART SPEC. M304TS0.750W0.065
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 8) WEIGHT: D2221-1 = 4.57 lbs; D2221-5 = 0.90 lbs; D2221-7 2.65 = lbs

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 08/11/18

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DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	AS	DRAWING NO.	REV. H
MFG. APPR.	MD	D2221	SHEET 5 OF 5
APPROVED	MD	TITLE	SCALE
DE APPR.	MD	BASKET BASE ASSEMBLY (350) NTS	
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